

Work Order ID 121312

June-23-14 2:58:48 PM

121312

Page 1

Item ID: D5061-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Wearplate

Start Date: 6/23/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/26/14 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5061	A								

110

0.00

110

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1- Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

2 A 14-6-24

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

2 A 14-6-24

130

0.00

130

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

EB DAS
14/6/24 27
9-89

(2)

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Item ID: D5061-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Wearplate
 Start Date: 6/23/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 6/26/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Form as per dwg NC BRAKE	0.00							
140									
Brake NC	Memo	0.00		DAS 30 30		2			14/20/20
Brake NC	Form joggle as per dwg.								
150	QC6- Inspect dimensions to drawing	0.00							
150									
QC	Memo	0.00							8 14/20/07
Quality Control									
160		0.00							
160	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld hard surface as per QSI 004 and Dwg D5061 2059 Hardcoat Rod								15-06-26 JBL

129283

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Page 3

Item ID: D5061-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Wearplate
 Start Date: 6/23/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/26/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS 9 9-89
170						(2)	15-06-29		
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
180						(2)	15-06-29		
QC	Memo	0.00							
Quality Control									
183		0.00							DAS 41 9-89
183						2			
HandFinish	Memo	0.00							
Hand Finishing	APPLY ROCKGARD AS PER DWG								15-6-29
	A/R ROCKGARD BATCH: <u>132390</u>								

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Item ID: D5061-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Wearplate
 Start Date: 6/23/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/26/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
186	QC3- Inspect Part Finish	0.00							DAS 38 9-89

186

QC

Memo

0.00

Quality Control

JUN 29 2015

190 Identify as per dwg & Stock Location: FP-002 0.00
 Packaging

190

Packaging

Memo

0.00

Packaging

x2 / 211 15/06/29

200 QC21- Final Inspection - Work Order Release 0.00

200

QC

Memo

0.00

Quality Control

MLJ JUN 30 2015

MLJ JUN 29 2015
 JUN 30 2015

Picklist Print

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Page 1

Work Order ID: 121312

121312

Parent Item: D5061-3

D5061-3

Parent Item Name: Aft Wearplate

Start Date: 6/23/14

Required Date: 6/26/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.02.13 NEW ISSUE DD VERF:JLM
REV:B 14.04.21 rev.A DD VERF:JLM

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

sf

727.5100

7

M304S18GA

EL 14-6-24

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT019

715.51

117188

3

117766

5

120604

5

122325

3

123155

3

124572

38

M126647

31.55

M128254

97.71

6.14

M128435

123.25

M128864

126

M129530

280

MAT020

12

124029

2

M126098

10

DART AEROSPACE LTD		Work Order: 121312
Description: Alt Wrapslot		Part Number: D5061-3
Inspection Dwg: D5061 Rev: A		Page 1 of 1

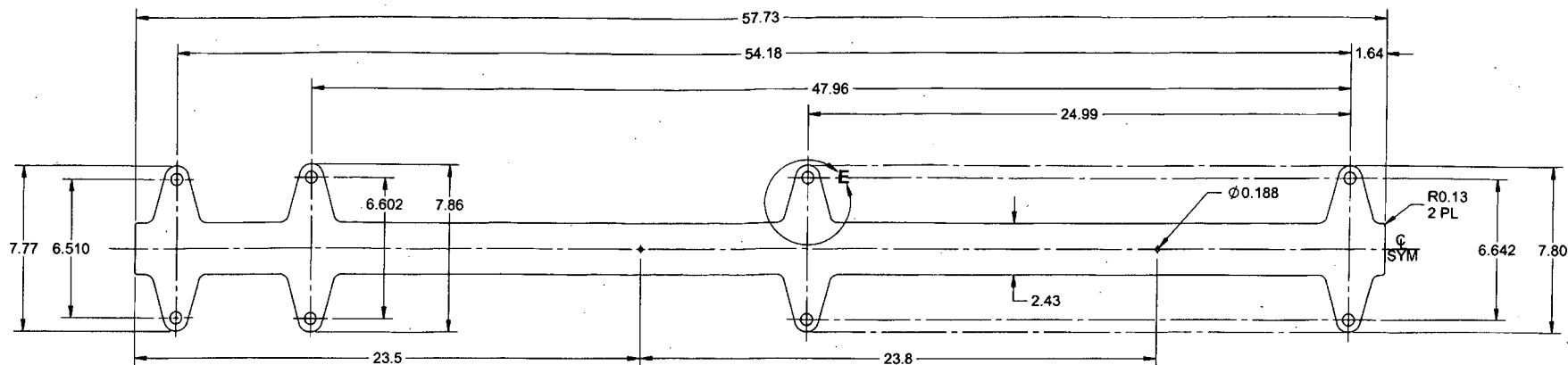
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
57.73	+/- 0.03	57.73	✓		1 JRM06	
54.18	+/- 0.03	54.18	✓		"	
47.96	+/- 0.03	47.97	✓		"	
24.97	+/- 0.03	25	✓		"	
1.64	+/- 0.03	1.67	✓		1 JRM05	
6.642	+/- 0.01	6.644	✓		"	
7.80	+/- 0.03	7.8	✓			
2.43	+/- 0.03	2.443	✓			
7.86	+/- 0.03	7.866	✓			
6.602	+/- 0.010	6.596	✓			
6.55						
6.510	+/- 0.010	6.509	✓			
7.77	+/- 0.03	7.747	✓			
0.561	+/- 0.01	0.562	✓			
0.531	+/- 0.01	0.531	✓			

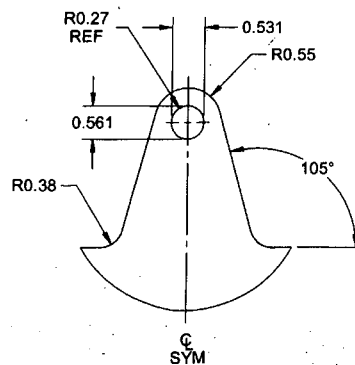
Measured by: <i>ea</i>	Audited by: <i>EB</i> ^{DAS} 27	Preliminary Approval:
Date: 14-6-24	Date: 19/6/24	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



D5061-3F AFT WEARPLATE



DETAIL E
SCALE 3X
4 PL

NOTES:

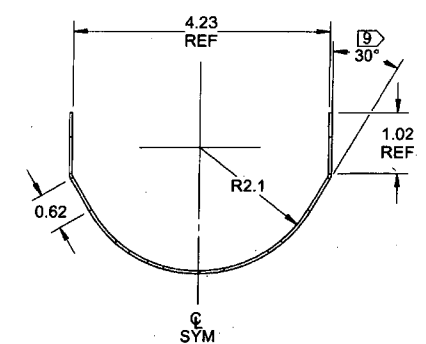
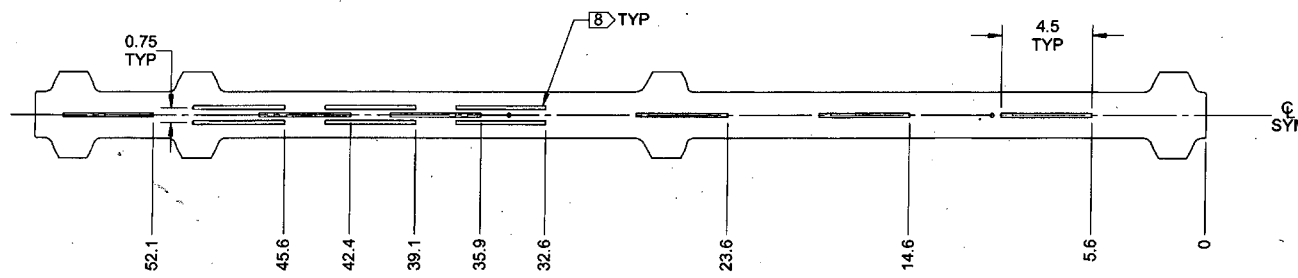
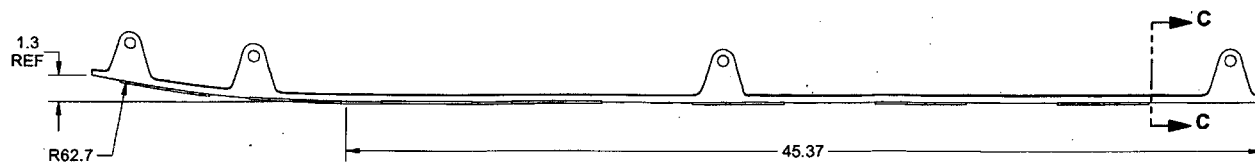
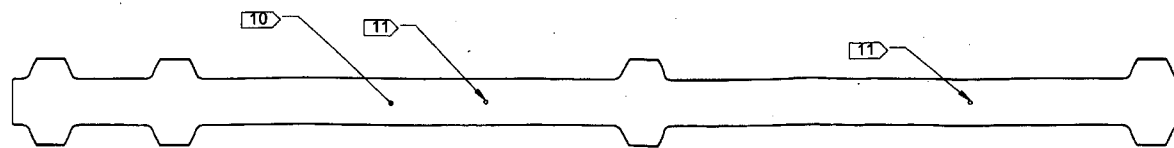
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

WLB 21312

RELEASED
2014-04-15
AP

APPROVED

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5061	SHEET 5 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
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D5061-3 AFT WEARPLATE
(MAKE FROM D5061-3F)

SECTION C-C
SCALE 3X

NOTES:

- 1) MATERIAL: MAKE FROM D5061-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 2.7 lbs
- 8) WELDING: PER QSI 004, APPLY LAYER OF 2059 HARDCOAT WELD TO 0.063 - 0.125 HIGH AFTER BENDING
- 9) IT IS ACCEPTABLE TO OVERBEND UP TO 2 DEGREES OR UNDERBEND UP TO 5 DEGREES.
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THK PER QSI 005 4.9
- 11) OPEN UP DRAIN HOLE IF NECESSARY TO Ø0.188 AFTER APPLYING TEXTURED COATING

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO. D5061	REV. A
MFG. APPR.	DD	SHEET 3 OF 5	
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DE APPR.	DS	WEARPLATE	NTS
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2014-04-15